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D044-717-011
Job Sheet 192885



Part No: D044-717-011

Job Qty: 1 pcs

Part Name: R44 Cold Weather Baffle



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/3/19

Job Tracking No:

Due Date: 4/29/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV N/A IPP Rev:B Removed Manufacturing 05-12-06 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	1 pcs	4/29/19		0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		APR 07 2019
							Packaging 1 - 23	PC.	
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		
							Packaging 1 - 31		

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Container No: S170528

Part: D044-717-011

Job No: 192885

Serial No/Batch: S170528

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH05 - 7 Issue 1 of 5 A.S.T.C. SR02148N

					Packaging 1 - 32	
					Packaging 1 - 33	
					Packaging 1 - 34	
					Packaging 1 - 35	
					Packaging 1 - 36	
120 QC 4	1 pcs	4/29/19	0.00 0.00		QC 4 - 28	
					QC 4 - 58	
					QC 4 - 69	
					QC 4 - 9	
					QC 4 - 46	
130 Packaging 3-1 - Stock - B4B	1 pcs	4/29/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
135 DC - 1 - B4B	1 pcs	4/29/19	0.00 0.00		DC - 1 - B4B	
					DC - 2 - B4B	
140 QC 21 - FG	1 pcs	4/29/19	0.00 0.00		QC 21 - FG - 21	
					QC 21 - FG - 70	
					QC 21 - SA - 53	
Part Op 110 - (Pick Kit)						
Descriptions: 120 - (QC4- 100% Inspect kits for completeness) QC4- 100% Inspect kits for completeness						
130 - (Identify as per dwg & Stock Location: _____) Identify and pack for shipping as per PPP D044-717-011 Location: FG027						
135 - (Document Control) Photocopy bluefile and create labels per PPP D044-717-011CHG001						
140 - (QC21- Final Inspection - Work Order Release) QC21- Final Inspection - Work Order Release						

009148

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
327 AN526C1032R7	Screw	8 Ea (8 ea)	110-Packaging 1 - Pick Kit	FA128403
493 D3276-041	Baffle Assembly LH	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	S041359
493 D3276-042	Baffle Assembly RH	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	F79183
033 D3383-1	Placard	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	S160503
112 MS20426AD3-4	Rivet	16 Ea (16 ea)	110-Packaging 1 - Pick Kit	FM1364144
301 MS21059L3	Nut Plate	8 Ea (8 ea)	110-Packaging 1 - Pick Kit	S168249X3
				S162136XF

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	AN526C1032R7	8	110	0
	D3276-041	1	1	0
	D3276-042	1	1	0
	D3383-1	1	6	0
	MS20426AD3-4	16	2,545	0
	MS21059L3	8	375	0

Part Specifications

Specifications could not be found.

Plex 4/3/19 11:13 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

CHAPTER 53 – FUSELAGE (53-00-00)**53.1 COLD WEATHER BAFFLE KIT REMOVAL**

The Dart D044-717-011 Cold Weather Baffle Kit should be removed as follows:

- 53.1.1 Unfasten the qty(4) AN526C1032-7 screws securing the D3276-041 Baffle Assembly to the LH inlet. Remove the baffle assembly.
- 53.1.2 Unfasten the qty(4) AN526C1032-7 screws securing the D3276-042 Baffle Assembly to the RH inlet. Remove the baffle assembly.
- 53.1.3 If removing because temperatures are above -10°C (14°F), plug all nut plates with the AN526C1032-7 screws.

53.2 COLD WEATHER BAFFLE KIT REINSTALLATION

The Dart D044-717-011 Cold Weather Baffle Kit should be reinstalled as follows:

- 53.2.1 Locate the D3276-041 Baffle Assembly on the LH inlet as shown in Figure 0-1 so that holes in baffle line up with nut plates that have already been installed in airframe. Install using qty(4) AN526C1032-7 screws. Torque screws 15-25 in-lb (2-3 Nm)
- 53.2.2 Repeat installation for RH side using D3276-042 Baffle Assembly.

53.3 WEIGHT AND BALANCE

The following is the net weight increase associated with the installation.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D044-717-011	0.86 lb	0	0	160 in	138 in-lb
Cold Weather Baffle Kit	0.39 kg	0	0	4.06 m	1.6 m-kg

53.4 PARTS LIST

Qty -011	Part Number	Description
X	D044-717-011	COLD WEATHER BAFFLE KIT
1	D3276-041	BAFFLE ASSEMBLY, LH
1	D3276-042	BAFFLE ASSEMBLY, RH
1	D3383-1	PLACARD
8	AN526C1032-7	SCREW
16	MS20426AD3-4	RIVET
8	MS21059L3	NUTPLATE

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53-00-00

Change Record

Part Number D044-717-011Description COLD WEATHER BAFFLE KITPage 1 of 1[illegible]